

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET ASS'Y
Job Number	: 35379		
Estimate Number	: 12523		
P.O. Number	: <i>NA</i>	Part Number	: D35313
This Issue	: 10/25/2007 S.O. No. : <i>NA</i>	Drawing Number	: D3531 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>NA</i> Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 34827	Material	: <i>NA</i>
Written By	: <u><i>[Signature]</i></u>	Due Date	: 11/15/2007
Checked & Approved By	: <u><i>[Signature]</i></u>	Qty:	<i>11</i> / 8 Um: Each
Comment	: Est Rev: A New Issue 07-09-24 EC verified by DD		

Job Number:



1.0 M6061T6S040 6061-T6 .040 Sheet



15169



6061-T6 .040 Sheet

(M6061T6S040)

Batch: 102723 LB 67-10-31

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3531

Dwg Rev: A HB 67-10-31

Prog Rev: A

2-Deburr if necessary **HR 07-10-31**

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 07-10-31



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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~~Comment: SMALL & MEDIUM FAB RESOURCE 1~~

Deburr if necessary.

$$\frac{u}{v}$$

Done at year 2.2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: AD Date: 21/1/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/25/2007 10:14:13 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASS'Y

Job Number: 35379

Part Number: D35313

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3530

SB 07/11/02

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S A/L 02/11/02 (11)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 07-11-04

(11)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf 07-11-05.

(11)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

mf 07-11-05.

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(11)
D A/L 05

Job Completion



C20711103

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	35379
Description: Bracket Front Plate		Part Number:	D3531-3
Inspection Dwg: D3531 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.129	X			
3.72	+/-0.030	3.72	X			
0.37	+/-0.030	.37	X			
2.840	+/-0.010	2.840	X			
0.88	+/-0.030	.88	X			
3.50	+/-0.030	3.498	X			
4.67	+/-0.030	4.667	X			

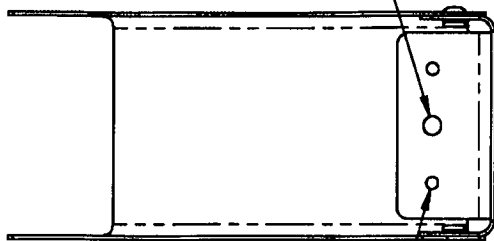
Measured by:	IB	Audited by:	ES	Prototype Approval:	N/A
Date:	07-10-31	Date:	07/10/31	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.15	New Issue	KJ/EC/DD	IB



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3531	REV. A SHEET 1 OF 3
DATE 07.06.19	TITLE BRACKET ASSEMBLY		SCALE 1:2
REV A	DATE 07.06.19	DESCRIPTION NEW ISSUE	

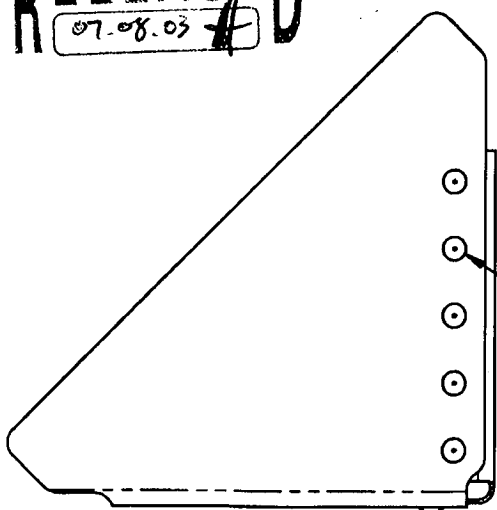
4
TRANSFER DRILL #9 ($\phi 0.196$)



TRANSFER DRILL #30 ($\phi 0.129$)
INSTALL MS20470AD4-4 RIVET
(2 PLACES)

4

RELEASED
07.08.03

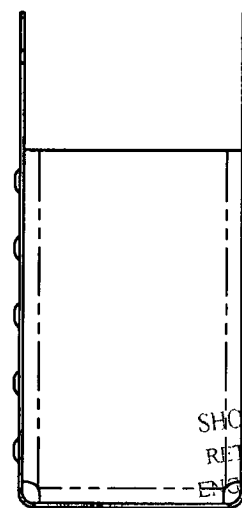
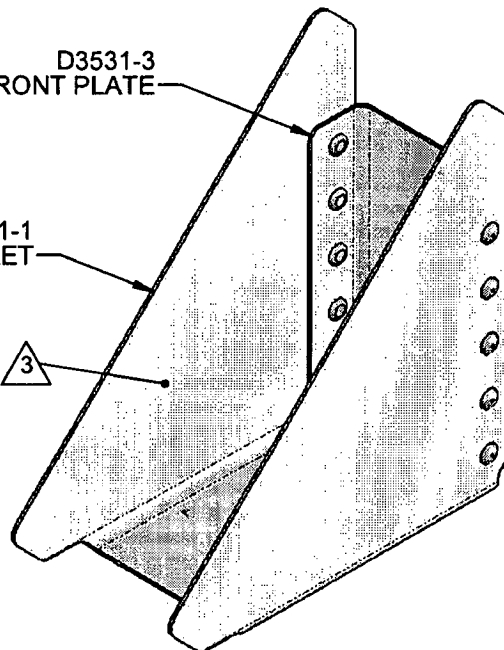


MS20470AD4-4
(10 PLACES)

D3531-3
BRACKET FRONT PLATE

D3531-1
BRACKET

3



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NO. 35319

D3531-041 BRACKET ASSEMBLY

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY BLACK
SANDTEX (4.3.5.7) PER DART QSI 005 4.3
ALL PARTS
- 2) ASSEMBLE PER DART QSI 003
- 3) IDENTIFY WITH DART P/N "D3531-041" USING
WHITE MARKER ON INSIDE OF BRACKET
ASSEMBLY, WHERE INDICATED
- 4) TRANSFER DRILL HOLES FROM D3531-1 BRACKET
THROUGH D3531-3 BRACKET FRONT PLATE
BEFORE FINISHING

PARTS LIST

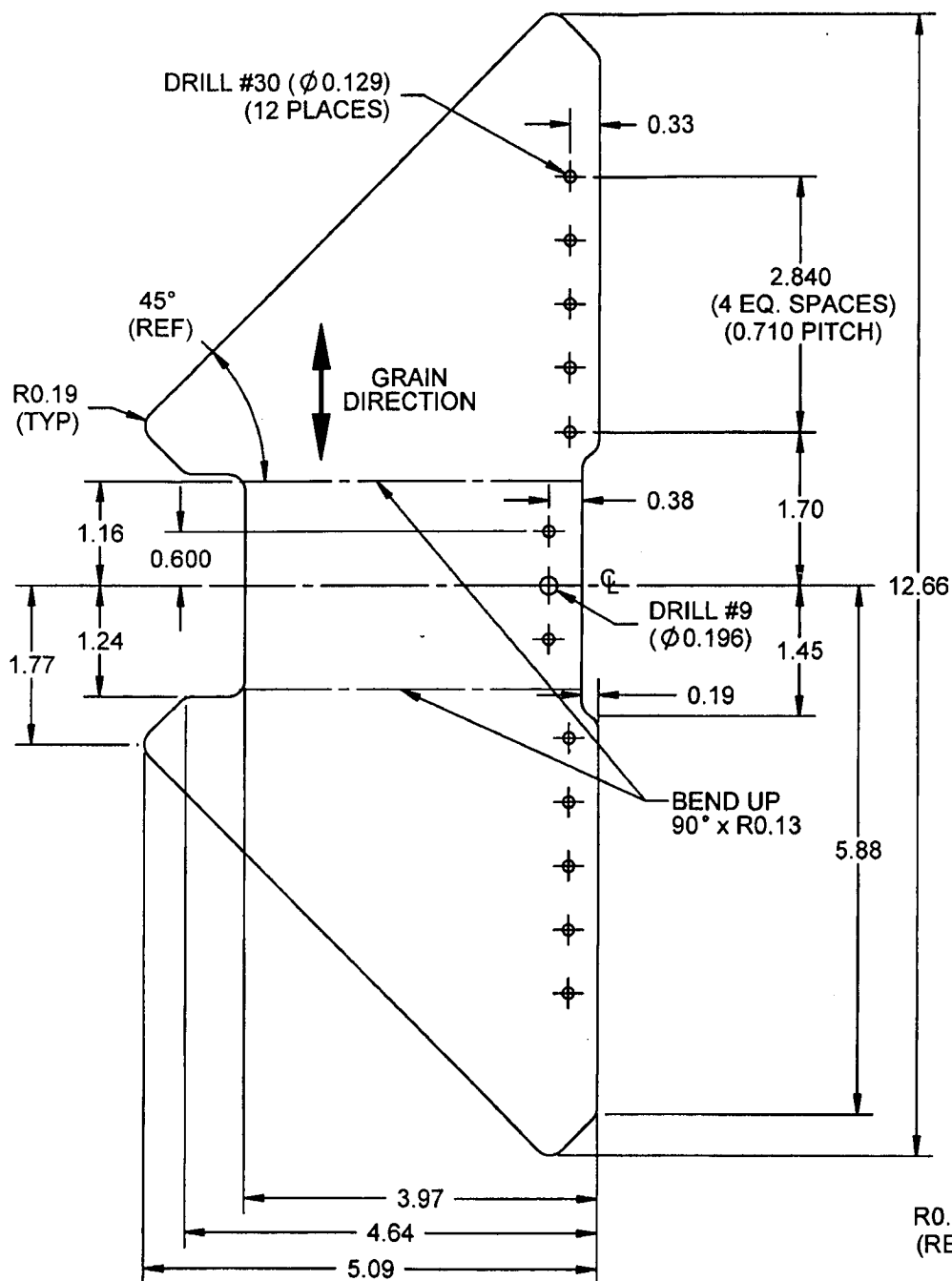
QTY.	P/N	DESCRIPTION
X	D3531-041	BRACKET ASSEMBLY
1	D3531-1	BRACKET
1	D3531-3	BRACKET FRONT PLATE
12	MS20470AD4-4	RIVET

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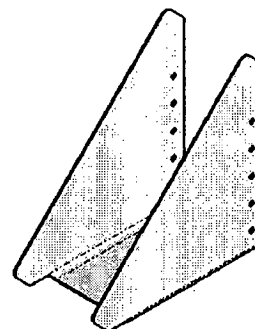
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CHECKED CE	APPROVED [Signature]	DRAWING NO. D3531	REV. A SHEET 2 OF 3
DATE 07.06.19		TITLE BRACKET ASSEMBLY	SCALE 1:2



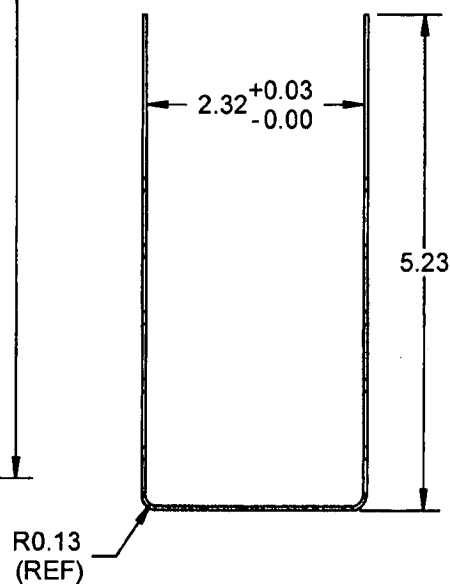
D3531-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ



RELEASED
07-08-03



D3531-1 BRACKET

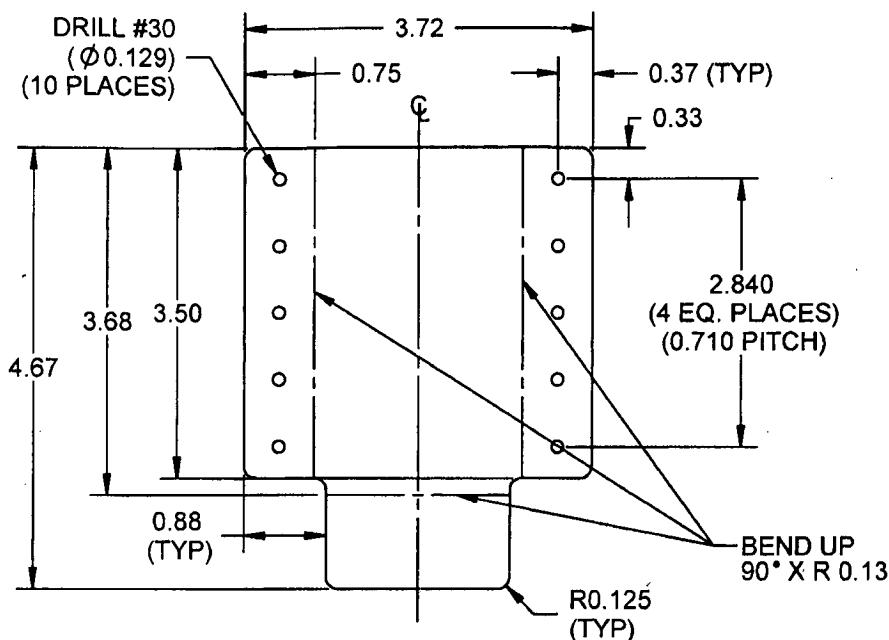
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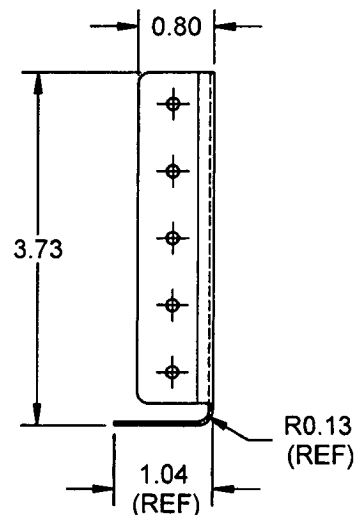
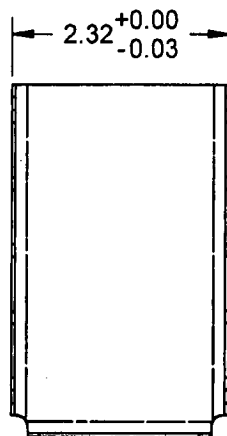
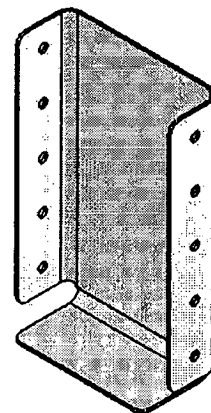


DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED H	DRAWING NO. D3531	REV. A SHEET 3 OF 3
DATE 07.06.19	TITLE BRACKET ASSEMBLY		SCALE 1:2



D3531-3F FLAT PATTERN

RELEASED
07.08.03



D3531-3 BRACKET FRONT PLATE

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ

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